

Work Order ID 83634

83634

Page 1

April-20-12 2:30:41 PM

Item ID: D3391-021

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Tube Assembly

Start Date: 20/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3391	I

100		0.00
-----	--	------

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

Cut extrusion to 46.52 +0.010 -0.020

DC 12/05/22

110

0.00

110

BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend as per Dwg D3391 Using Bend Prog 3391021

DC 12/05/31

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

DP 12-6-1

7.0"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83634

8.3634

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April-20-12 2:30:41 PM

Item ID: D3391-021

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Tube Assembly

Start Date: 20/04/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine as per Folio FA590 Rev. <u>1</u> & Dwg D3391 Rev. <u>1</u> Identify as D3391-1 2-Deburr	0.00 0.00		2	2	1	1		
140 *140* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		2	2	1	1		
150 *150* Mill Conv Conventional Milling Machine	CONVENTIONAL MILLING MACHINE Memo Drill X1 Aft cap as per Dwg D3391 .1875" dia	0.00 0.00				1	1		

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D3391-021

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Tube Assembly

Start Date: 20/04/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00

180

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

2-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr & Scribe Batch number Inside aft end.

7-Transfer drill D3391-021 with D3391-023

NO WEARPLATE HOLES ARE TRANSFER DRILLED

DC 12/06/20

DC 12/06/21

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

DAS
16
9-83

12/06/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Item ID: D3391-021

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Tube Assembly

Start Date: 20/04/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Chemical Conversion Coat per QS1005 4.1	0.00							
200									
HandFinish	Memo	0.00							
Hand Finishing									
210	QC7-Inspect Chemical Conversion Coat	0.00							
210									
QC	Memo	0.00							
Quality Control									
220		0.00							
220									
Skidtubes	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-instal spacers as per dwg D3391 A/R Magnabond 6398 batch: <u>M120666</u> exp. date: <u>13-1-30</u> cure time 12hrs. as per QS1015 2- grind crossbolt flush 3-back drill crossbolt if necessary								

-DC 12/08/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83634

8.36.34

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April-20-12 2:30:41 PM

Item ID: D3391-021 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Fwd Tube Assembly
Start Date: 20/04/2012 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 04/05/2012 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230 *230* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
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235 *235* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo AND REALODINE AS PER PAR09-043	0.00 0.00				1	76	12-8-23	
--	--	------------------	--	--	--	---	----	---------	--

240 *240* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 8-10 OVEN TEMPERATURE: 320 °F FINISH TIME: 8-40	0.00 0.00				1X	✓	12/08/23	MZ
--	---	------------------	--	--	--	----	---	----------	----

m121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D3391-021

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Fwd Tube Assembly

Stop

NS2

Start Date: 20/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

QC3- Inspect Part Finish

0.00

250

QC

Memo

0.00

Quality Control

1x d HU 11/08/27

255

Skidtubes

0.00

255

Skidtubes

Memo

0.00

Skidtubes

**** install D3591-1 spacer as per DSI9364 and wearplate as per DWG ****

1x d HU 11/08/27

257

QC5- Inspect part completeness to step on W/O

0.00

257

QC

Memo

0.00

Quality Control

DAS
16
2-5
11/08/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 83634

8.36.34

Page 8

April-20-12 2:30:41 PM

Item ID: D3391-021

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Tube Assembly

Start Date: 20/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260

Identify as per dwg & Stock Location: W10

0.00

0412-742-043/1387071

260

Packaging

Memo

0.00

Packaging

1x d 12/08/27

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

ck 12/8/28

ME
12-08-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

April-20-12 2:30:45 PM

Page 1

Work Order ID: 83634

83634

Parent Item: D3391-021

D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 20/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A05.09.13New issue KJ/JLM
 IPP B06.02.10Dwg rev.D ecn 773 EC
 IPP C06.05.02Added inspections EC
 IPP D 07.03.13 rev F dwg EC
 IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD
 IPP Rev:f ECN 1056 07-11-12 DD verified by: EC
 IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC
 IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC
 IPP Rev I 09.02.02 added hardware EC verified by: DD IPP Rev:J
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4095-051		Manufactured	No			255	Each	29.0000	1	1			
D4095-051									**			21 12/08/27	
Wearpad Assembly													

Location	Loc Qty	Loc Code
FP002	29	
78914	7	
81613	22	

D6013-047		Manufactured	No			100	Each	102.0000	1	1			
D6013-047									**			DE 12/05/22	
Skidtube Material													

Location	Loc Qty	Loc Code
LG	102	
72505	102	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

April-20-12 2:30:45 PM

Page 2

Work Order ID: 83634

83634

Parent Item: D3391-021

D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 20/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

220

Each

55.0000

4

4

D3670-4-200

SPACER

**

Location

Loc Qty

Loc Code

LG

B85466

40

80360

40

LG001

15

72851

3

78606

12

D3401-041

Manufactured No

255

Each

17.0000

1

1

D3401-041

Tow Cap Assembly

**

Location

Loc Qty

Loc Code

FP002

17

78990

2

82302

15

AN960C10L

NAS1149C0332

Purchased

No

255

Each

0.0000

10

10

*AN960C10I *y

washer

AN3C4A

Purchased

No

255

Each

2,292.000

10

10

AN3C4A

BOLT

**

Location

Loc Qty

Loc Code

ST350

2292

120187

1226

120521

28

120769

38

121205

1000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

April-20-12 2:30:45 PM

Page 3

Work Order ID: 83634

83634

Parent Item: D3391-021

D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 20/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

255 Each

960.0000 4 4

D3672-1

Phenolic Washer

**

yl 12/08/27

Location

Loc Qty

Loc Code

FP001

10

66821

10

ST060

950

72229

4

76277

446

80369

500

x 4

AELS-1032-225

Purchased No

255 Each

0.0000 10 10

AFI S-1032-225

INSERT

ALS4-1032-225 / M122290

**

(10) M 12/08/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Dart Aerospace Ltd

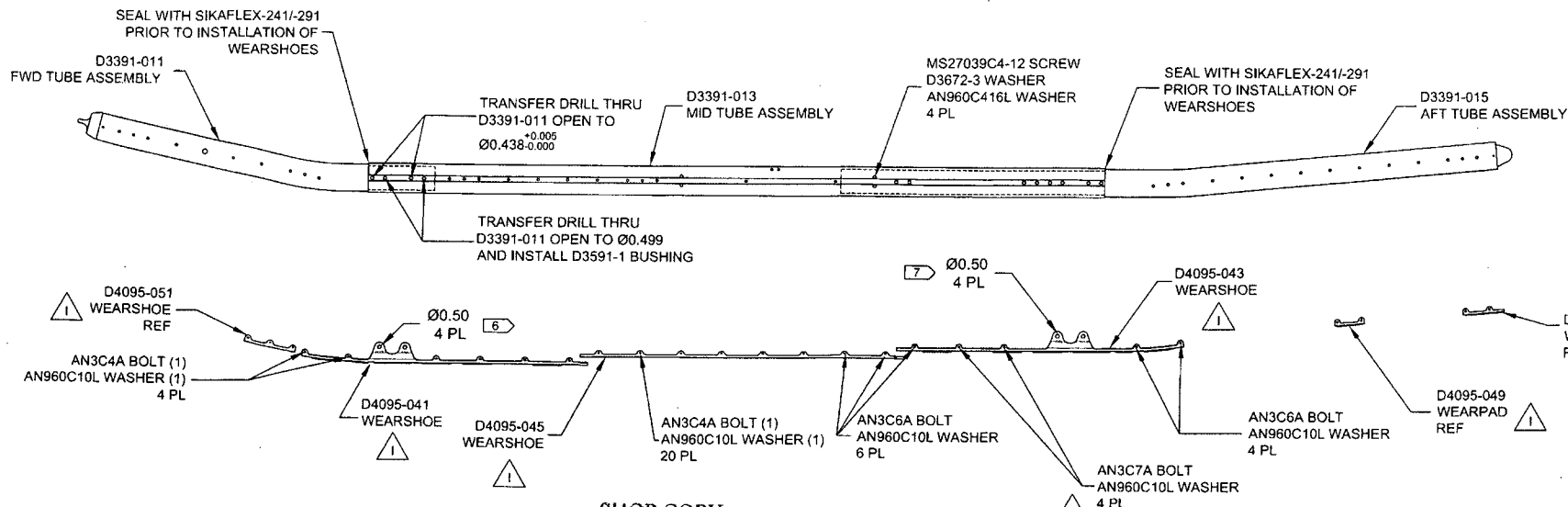
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NOTE: Date & initial all entries



SHOP COPY D3391-041 ASSEMBLY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 03634 MW
12/04/20

RELEASED
 2011-11-04
 ECN# 11-662

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8, LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8, REMOVED HOLES, ZN D8-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.13		

DART AEROSPACE USA, INC
 KENT, WA
 DRAWING NO. **D3391**
 SHEET 1 OF 8
 TITLE **412 FLOAT SKIDTUBE**
 SCALE **NTS**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

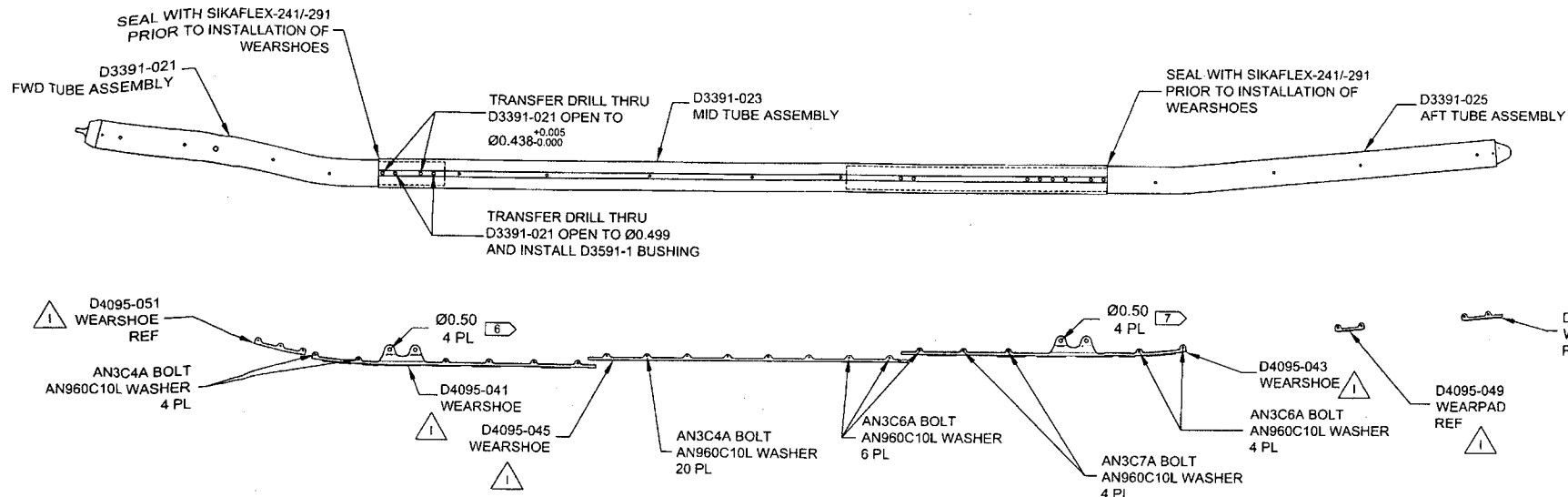
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83634



D3391-043 ASSEMBLY





D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
36	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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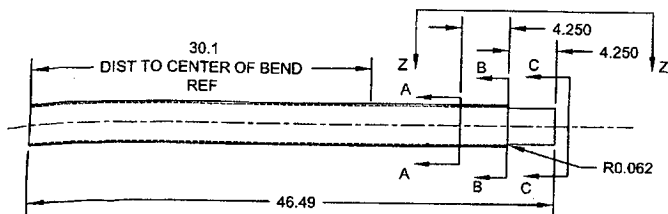
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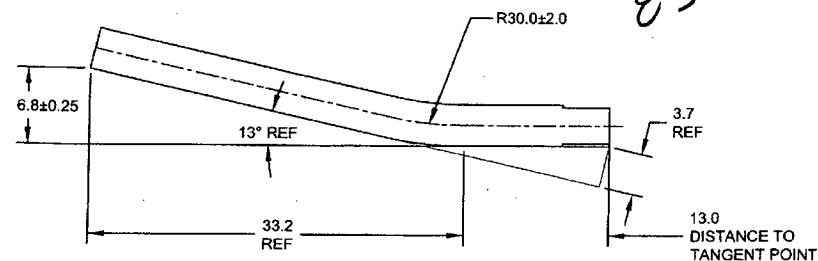
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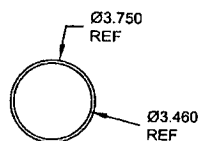
NOTE: Date & initial all entries



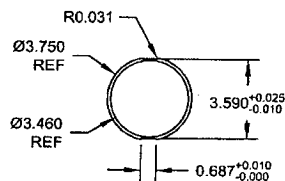
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



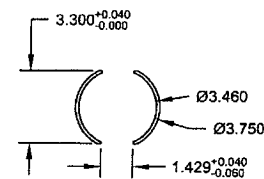
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



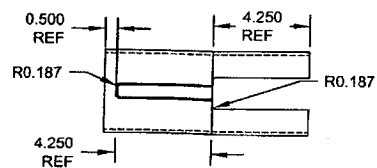
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

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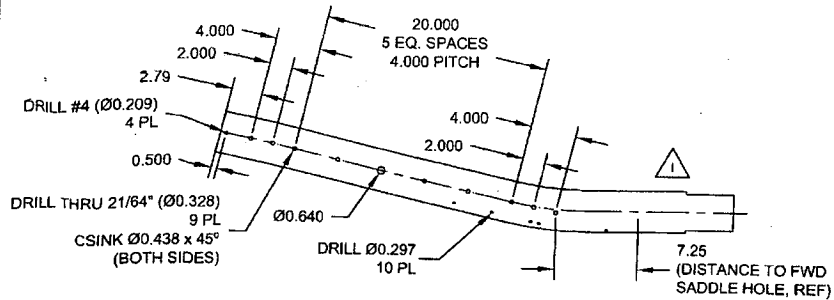
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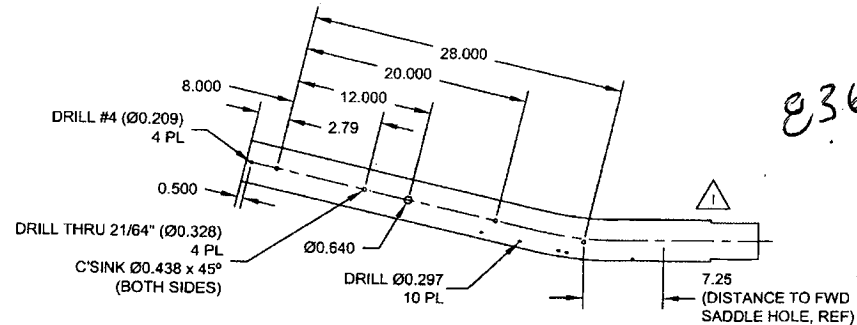
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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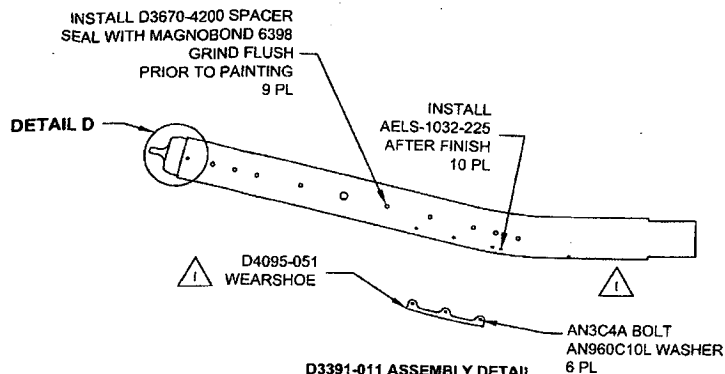
83634



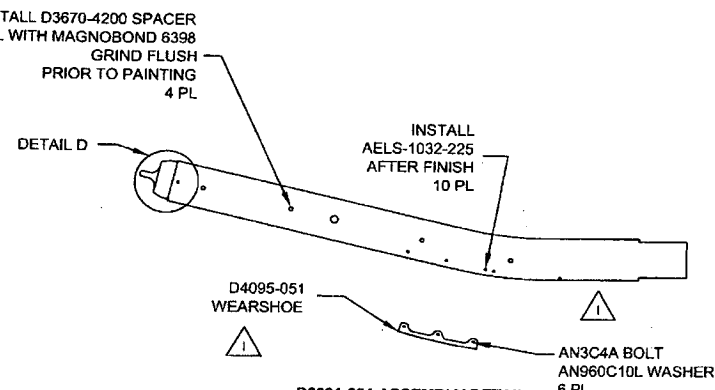
D3391-011 DRILLING DETAIL



D3391-021 DRILLING DETAIL



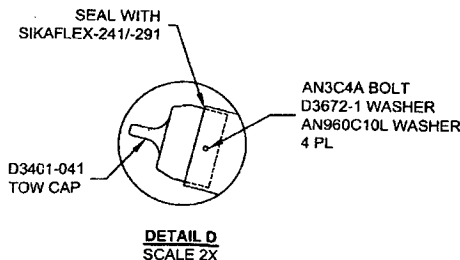
D3391-011 ASSEMBLY DETAIL



D3391-021 ASSEMBLY DETAIL

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D3401-041	TOW CAP
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
1	1	D4095-051	WEARSHOE
1	1	D6013-047	FWD TUBE
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
10	10	AELS-1032-225	INSERT



**DETAIL D
SCALE 2X**

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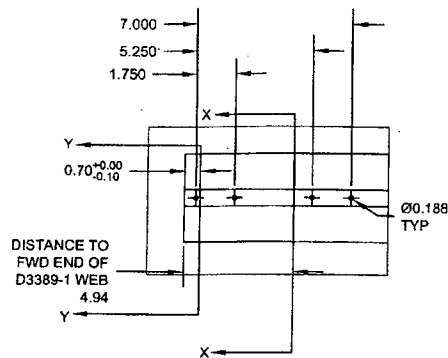
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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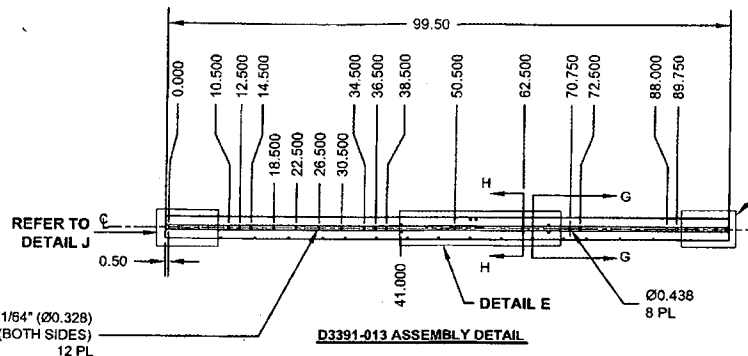
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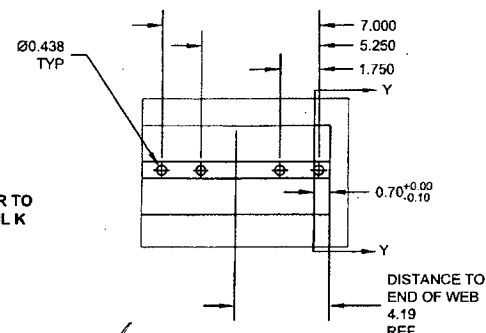


DETAIL J
SCALE 4X

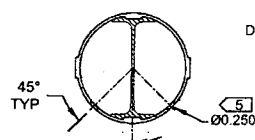
DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL



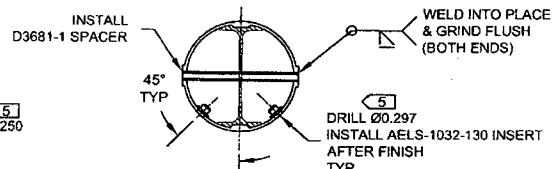
D3391-013 ASSEMBLY DETAIL



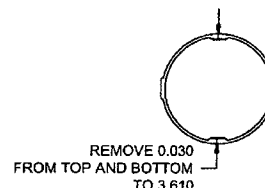
DETAIL K
SCALE 4X



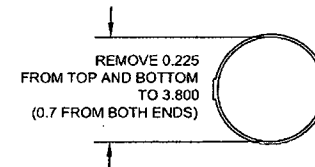
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



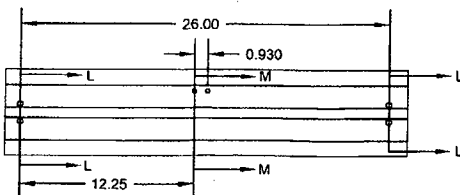
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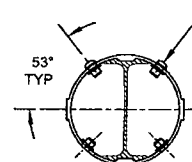
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

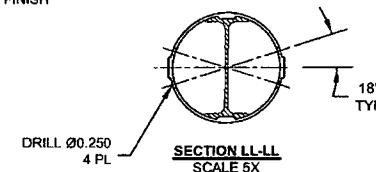
QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



DETAIL E
SCALE NONE

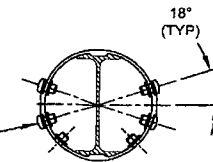


SECTION M-M
SCALE 5X



SECTION LL-LL
SCALE 5X

DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
4 PL



SECTION L-L
SCALE 5X

D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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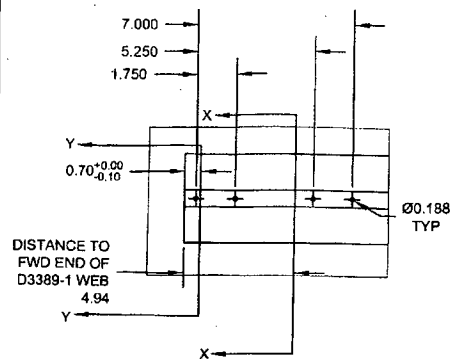
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

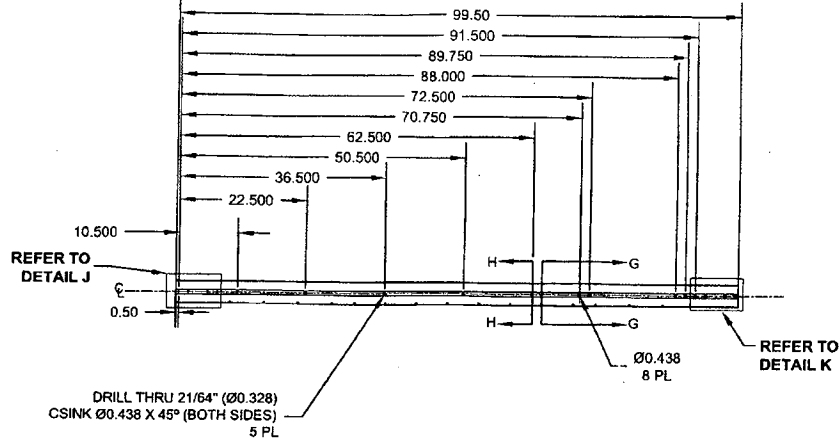
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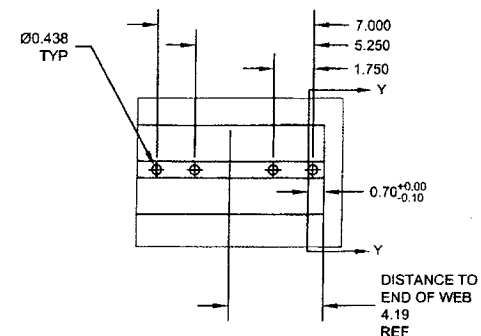
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DETAIL J
SCALE 4X



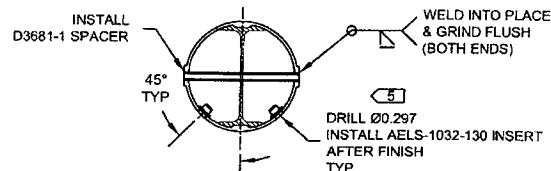
D3391-023 ASSEMBLY DETAIL



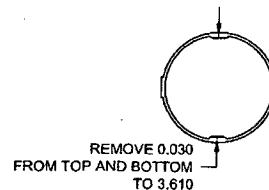
DETAIL K
SCALE 4X



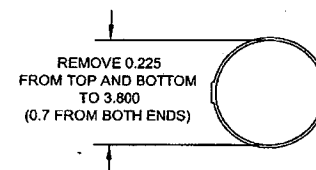
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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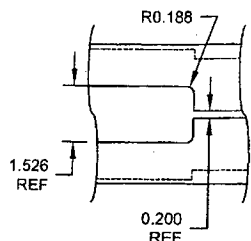
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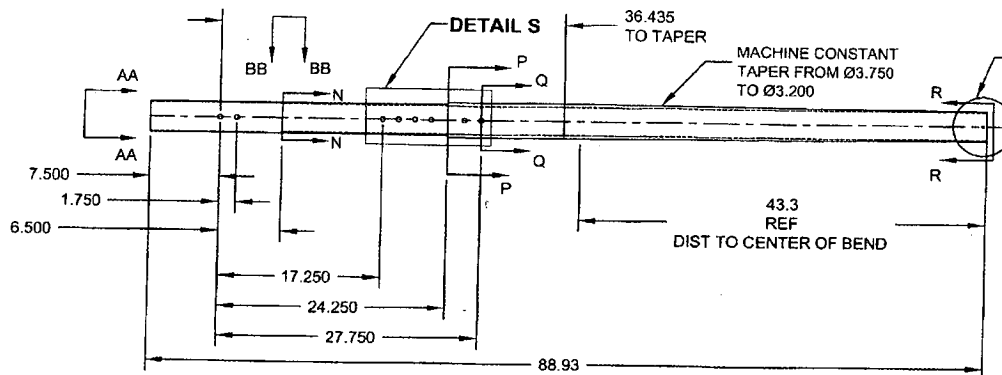
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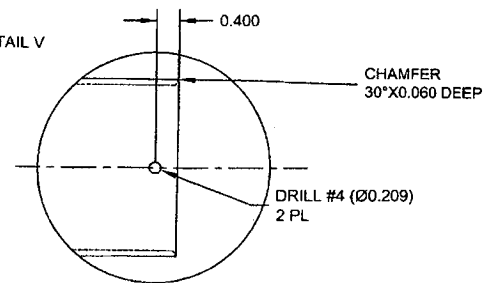
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VIEW BB-BB
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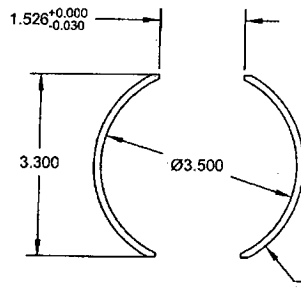


D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)

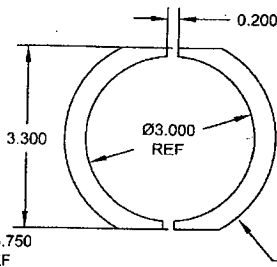


DETAIL V
SCALE 6X

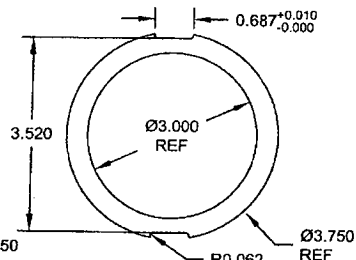
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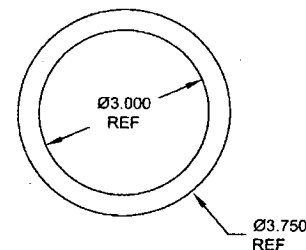
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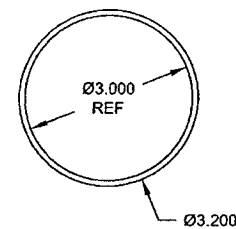
SECTION N-N
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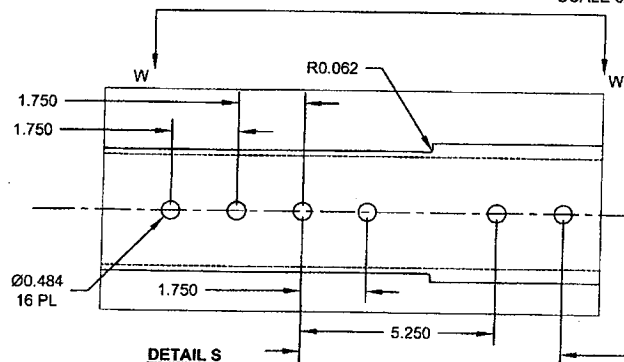
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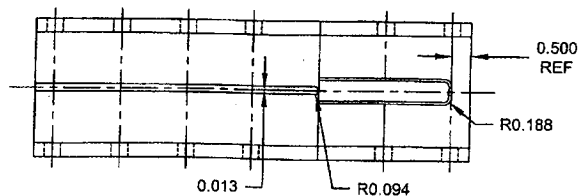
SECTION Q-Q
SCALE 6X



SECTION R-R
SCALE 6X



DETAIL S
SCALE 4X



VIEW W-W
SCALE 4X

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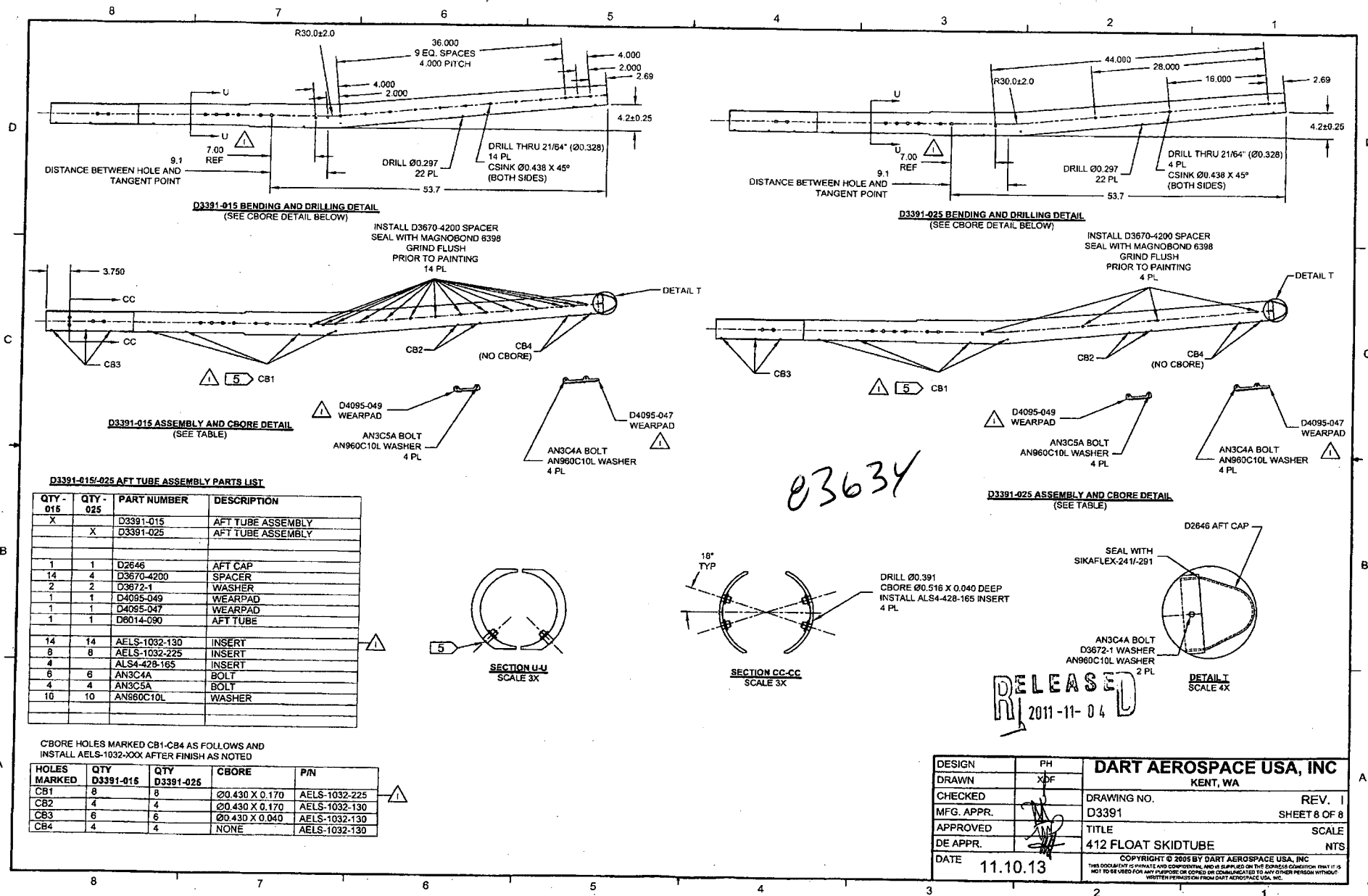
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